EAGLE

Work Order ID 52948

October 19, 2009 11:49:40 AM

Item ID: D3983-1
Revision ID: A
Item Name: Outer Closeout

Start Date: 10/19/09 **Start Qty:** 1.00
Required Date: 10/23/09 **Req'd Qty:** 1.00
Reference:

Accept **Setup Start** **Stop**

Cust Item ID:
Customer:

Run Start **Stop**

Approvals: **Process Plan:** RL **Date:** 9-10-09 **Tooling:** **Date:**
QC: **Date:** **SPC (Y/N):** **Date:**

Draw Nbr	Revision Nbr
D3983	A

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100		0.00							
Waterjet	**Memo**	0.00							HB 9-10-20
FLOW CNC Waterjet	1-Cut as per Dwg D3983 Dwg Rev: A Prog Rev: A 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00							HB 9-10-20
Quality Control									

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Accept **Setup Start** **Stop**

Cust Item ID:
Customer:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 0.00				(X3)	0		
130 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 **Memo**	0.00 0.00				(3)			
140 QC Quality Control	QC3- Inspect Part Finish **Memo**	0.00 0.00				(X3)			

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Start Date: 10/19/09 **Start Qty:** 1.00
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Reference:

Accept **Setup Start** **Stop**

Cust Item ID:
Customer:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location:_____	0.00							
Packaging	**Memo**	0.00							
Packaging	Send to Harvey 1pc ECN 09.67D ENG01060ct								
160	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

09/10/23 MF
09-10-23

Picklist Print

October 19, 2009 11:49:45 AM

Work Order ID: 52948

Parent Item: D3983-1

Parent Item Name: Outer Closeout

Comments:

Start Date: 10/19/09 **Required Date:** 10/23/09

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased	No			100	sf	96.5419	0.6435	2.000		
6061-T6 .040 Sheet											9-10-26	

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
MAT	96.5419		
100742	3.3		
102723	7.93		102723
105842	12		
106747	9.2116		
107461	12.4674		
109396	22.28		
111224	27.8529		
19380	1.5		

DART AEROSPACE LTD	Work Order:	52946
Description: Outer Closeout	Part Number:	D39834
Inspection Dwg: D39834 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

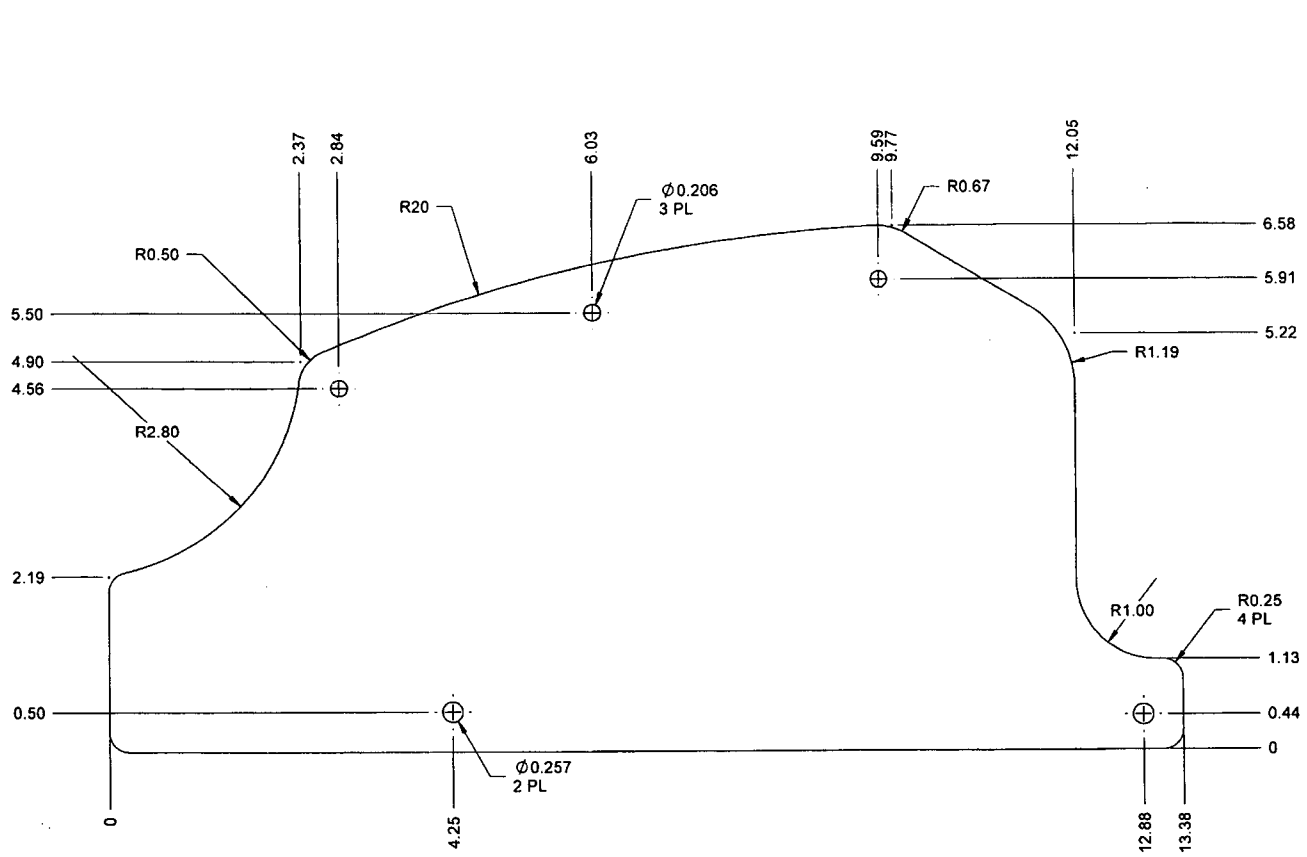
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .257	+.006 -.001	.260	✱			
Ø .206	+.005 -.001	.209	✱			
.50	+/- .030	.501	✱			
2.19	+/- .03	2.194	✱			
4.56	+/- .030	4.559	✱			
5.56	+/- .030	5.504	✱			
2.84	+/- .030	2.845	✱			
6.03	+/- .030	6.049	✱			
9.59	+/- .030	9.586	✱			
12.05	+/- .030	12.048	✱			
6.58	+/- .030	6.577	✱			
5.91	+/- .030	5.915	✱			
1.13	+/- .030	1.130	✱			
.44	+/- .030	.447	✱			
4.25	+/- .030	4.257	✱			
12.88	+/- .030	12.88	✱			
13.38	+/- .030	13.375	✱			
.040	+/- .010	.040	✱			

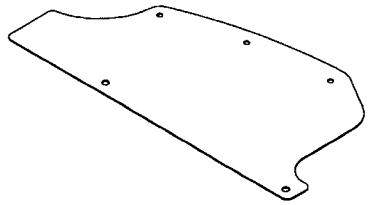
Measured by:	HB
Date:	9-10-26

Audited by:	S
Date:	09/10/20

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	







4.121

D3983-1 OUTER CLOSEOUT

12.75

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RL 09-1046

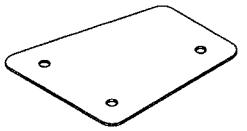
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2009 -10- 13

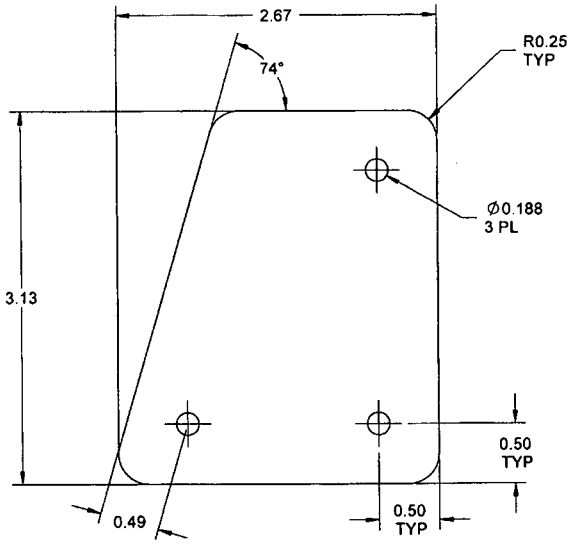
NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.040
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3983-1" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.26 lbs

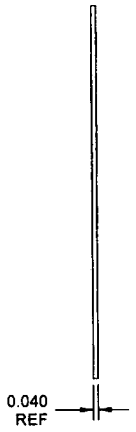
REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE		09.09.09

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3983	REV. A
MFG. APPR.			SHEET 1 OF 7
APPROVED		TITLE CLOSE OUT KIT	SCALE NTS
DE APPR.			
DATE	09.09.09		

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D3983-3 INNER CLOSEOUT

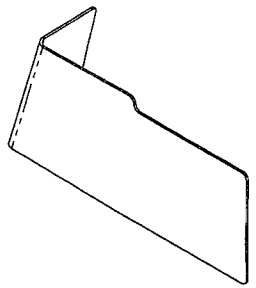
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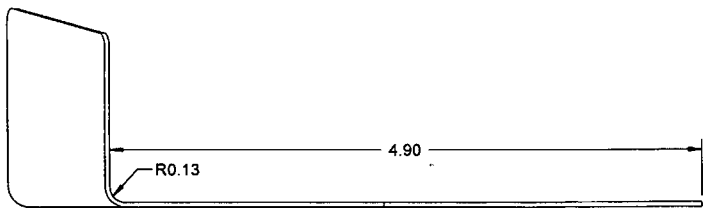
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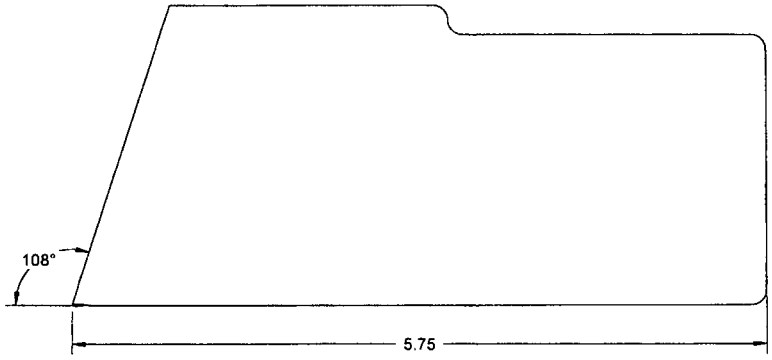
NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.040
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3983-3" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.03 lbs

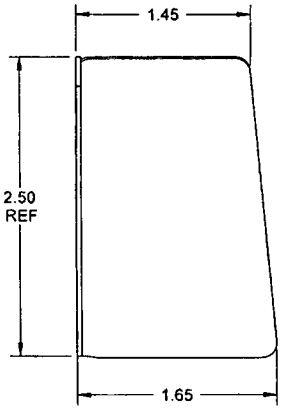
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DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3983 — REV. A — SHEET 2 OF 7
MFG. APPR.		TITLE: CLOSE OUT KIT — SCALE: NTS
APPROVED		
DE APPR.		
DATE 09.09.09		

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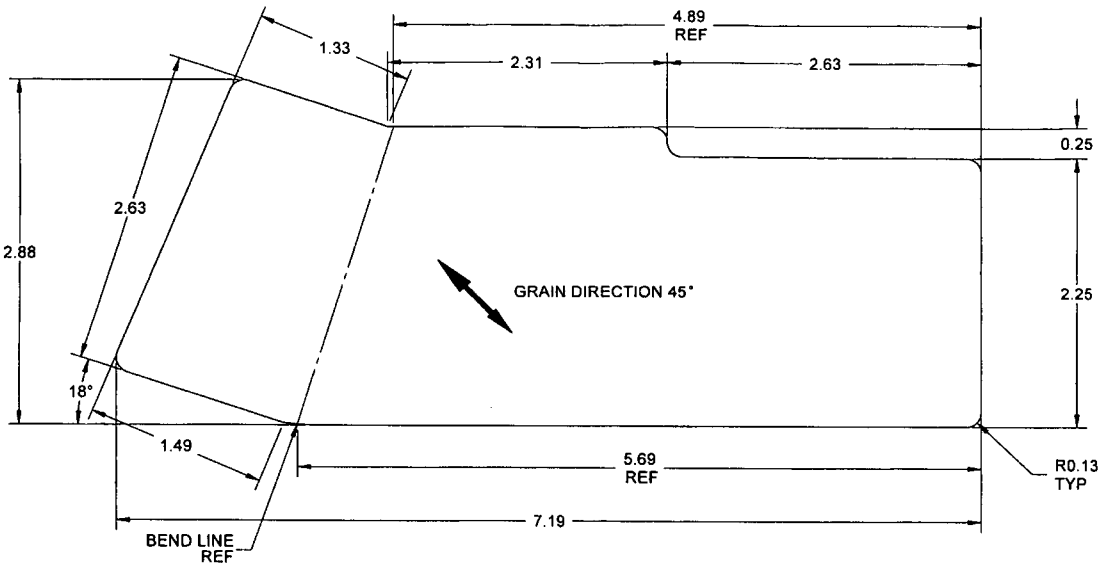
D3983-5 HINGE CLOSEOUT
(MADE FROM D3983-5F)

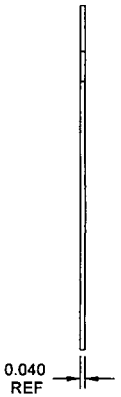
NOTES:
1) MATERIAL: D3983-5F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3983-5" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.06 lbs

DESIGN		**DART AEROSPACE LTD**
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3983 — REV. A — SHEET 3 OF 7
MFG. APPR.		TITLE: CLOSE OUT KIT — SCALE: NTS
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DATE	09.09.09	

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D3983-5F HINGE CLOSEOUT FLAT PATTERN

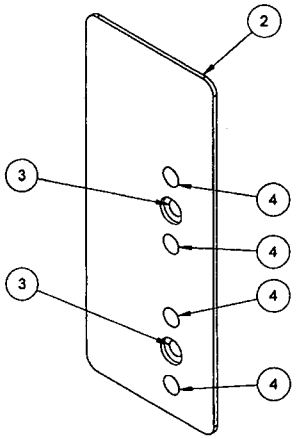
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NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.040
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.06 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D3983 REV. A
MFG. APPR.		SHEET 4 OF 7
APPROVED		TITLE CLOSE OUT KIT SCALE NTS
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DATE 09.09.09		

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ITEM	QTY. -047	PART NUMBER	DESCRIPTION
1	X	D3983-047	CLOSEOUT ATTACHMENT
2	1	D3983-7	PLATE
3	2	MS21059L3	ANCHOR NUT
4	4	MS20426AD3-4	RIVET



D3983-047 CLOSEOUT ATTACHMENT

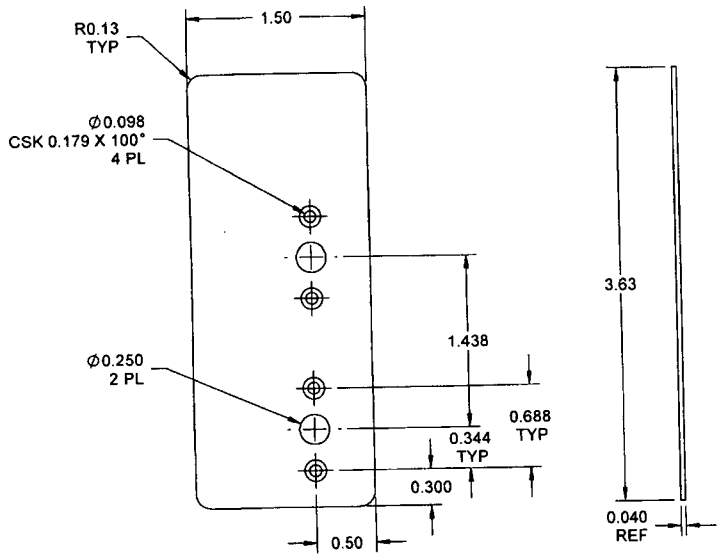
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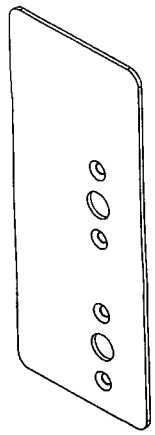
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NOTES:
1) MATERIAL: SEE BOM
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3983-047" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.03 lbs

DESIGN		DART AEROSPACE LTD
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CHECKED		DRAWING NO. D3983 REV. A
MFG. APPR.		SHEET 5 OF 7
APPROVED		TITLE CLOSE OUT KIT SCALE NTS
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DATE 09.09.09		

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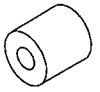
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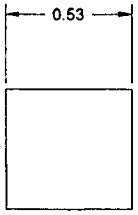
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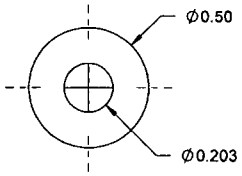
NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.040
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.02 lbs

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DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3983 — REV. A
MFG. APPR.		SHEET 6 OF 7
APPROVED		TITLE: CLOSE OUT KIT — SCALE: NTS
DE APPR.		
DATE	09.09.09	

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D3983-9 SPACER

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2009 -10- 13

NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR, Ø0.500
PER AMS-QQ-A-225/8 (OR AMS 4117/4122/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061TR
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3983-9" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.01 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D3983 — REV. A — SHEET 7 OF 7
MFG. APPR.		TITLE CLOSE OUT KIT — SCALE NTS
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